

ASAP

Dart Aerospace Ltd.

Date: Tuesday, 26/08/2008 7:28:44 AM
 User: Linda Lacelle

Process Sheet

Split

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : WEARPLATE
 Job Number : 41619 ~2
 Estimate Number : 10437
 P.O. Number :
 This Issue : 26/08/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D33191
 First Issue : / / Type : SMALL / MED FAB Drawing Number : D3319 REV. B
 Previous Run : 39564 Drawing Revision : B
 Material :
 Due Date : 02/09/2008 Qty: 12 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est: B 05.10.14 Added step 9, dwg rev B KJ/EC
 Est Rev: C Now on Waterjet 06-10-26 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M1010S18GA 1010/1025 SHEET .048



Comment: Qty.: 0.6594 sf(s)/Unit Total : 7.9128 sf(s)

1010/1025/A21/6aA SHEET .048

Batch: ~~105084~~

9.

104921 x 6 = 4
 105084 x 7 = 5

IB 8-8-26

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3319

Dwg Rev: B

Prog Rev: B

IB 8-8-26

(B)

2-Deburr if necessary

IB 8-8-26

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

IB 8-8-26

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

5 08/09/26 (X13)

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary

N/A

Done at 06/09/26 #2.2

Process Sheet

Part: CU-DAR001 Part Helicopters Services

Drawing Name: WEARPLATE

Number: 41619

Part Number: D33191

Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

1- Form using DT8326 & DT8261 as per Dwg D3319 Rev: B

2- Form flat on press using DT8776 block

SB 08/08/28 (4)

7.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

SO 08/08/28 (XU)

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- Layout weld location as per Dwg D3319 using jig D3319-1T3

2- Weld hard surface using D3319-1T2 per QSI 004 and Dwg D3319 Rev: B

Qty Part Number Description Batch

A/R N/A

7560 Hardcoat Rod

M106762

(X5)

FL 8-8-27

9.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

S

08/08/28

(X6)

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S

08/08/28

(X4)

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

11:45
320°F
12:15

M-L 08/09/02

(4X)

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

HL

08 09-02

(X4)

Process Sheet

mer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Number: 41619

Part Number: D33191

Number:



Seq. #:

Machine Or Operation:

Description :

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify on inside surface using a permanent fine point marker with the following:

TCCA-PDA, Dart Aerospace Ltd.

P/N: D3319-1, B/N: BXXXXX

For Product Eligibility see PDA05-18

and Stock

Location:

7969

81912

SP (4x)

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

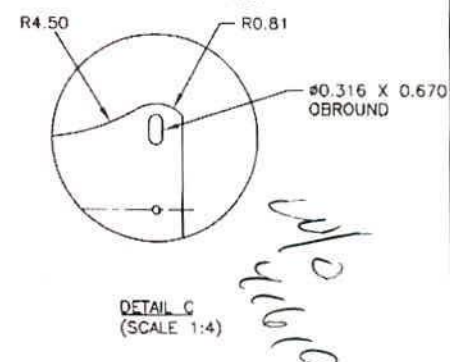
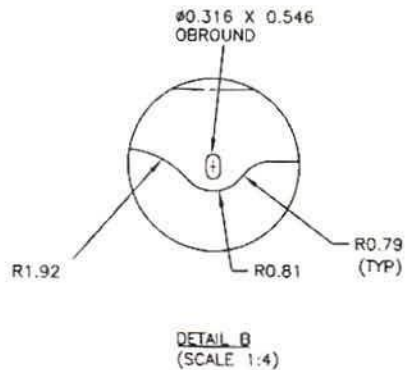
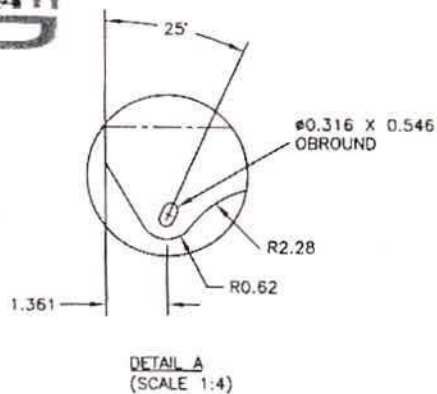
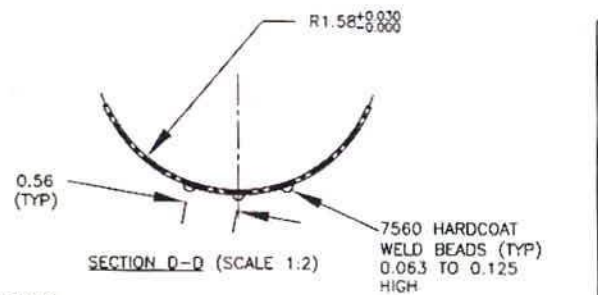
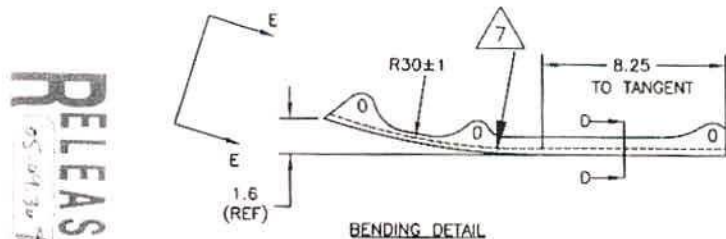
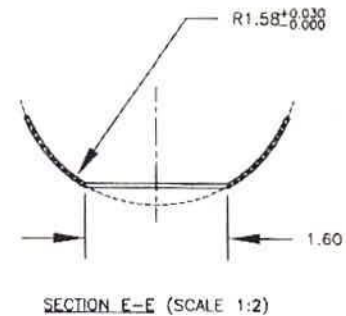
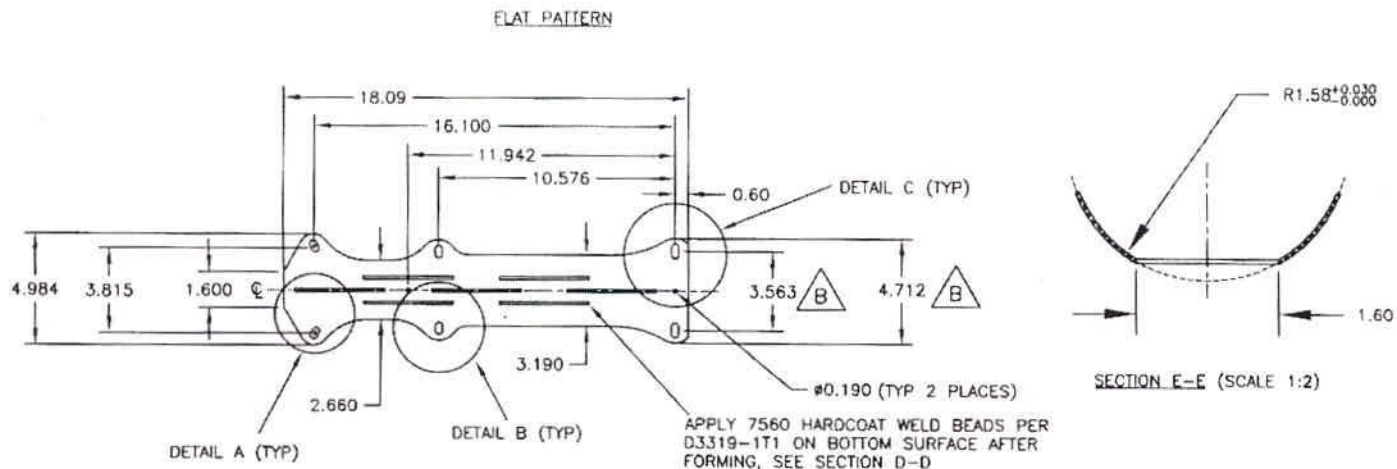
08/09/02 HJ

Job Completion



u 08.09.02

DART



D3319-1 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-POA, DART AEROSPACE LTD., P/N D3319-1 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-18"

| DESIGN | DRAWN BY | DART AEROSPACE LTD |
|----------|-----------|------------------------------------|
| F1 | 84 | HAWKESBURY, ONTARIO, CANADA |
| CHECKED | APPROVED | DRAWING NO. |
| 11 | 11 | D3319 |
| DATE | TITLE | SHEET 1 OF 5 |
| 05.06.06 | WEARPLATE | SCALE 1:8 |
| A | 04.09.24 | NEW ISSUE |
| B | 05.06.06 | WIDEN HOLES, REDUCE WIDTH -3/-5/-7 |

RELEASED
05-07-30